

Date: Wednesday, 2/21/2007 10:29:06 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL REF DOOR INSTALLATION
Job Number : 30784	
Estimate Number : 12741	
P.O. Number : N/A	Part Number : EA2046925
This Issue : 2/21/2007 S.O. No. : N/A	Drawing Number : D2046901
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : 1
Previous Run : N/A	Material : N/A
Written By : <u>SA/07.02.21</u>	Due Date : 2/28/2007
Checked & Approved By : _____	Qty: 2 Um: Each
Comment : rev A 07.02.21 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	EA2046929	ARM
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

ARM

batch: B3084607/02/22

2.0	EA2046928	ARM GUIDE
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

ARM GUIDE

batch: B3078307/02/22

3.0	EA2046922	LUG
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

LUG

batch: B3078507/02/22

4.0	EA2046926	DOOR PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOOR PLATE

batch: B3078707/02/22

5.0	EA2046927	DOOR PLATE
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOOR PLATE

batch: B3078607/02/22

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REF DOOR INSTALLATION

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Part Number: EA2046925

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D2046901

4130 welding rod batch: M9430

07/02/23 (2)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

EC 07.02.23 (2)

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 07.07.23 (2)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/02/23 (2)

Job Completion



07/02/23

8.1 Degrease, prime per dwg D2046901 ml 07.02.23

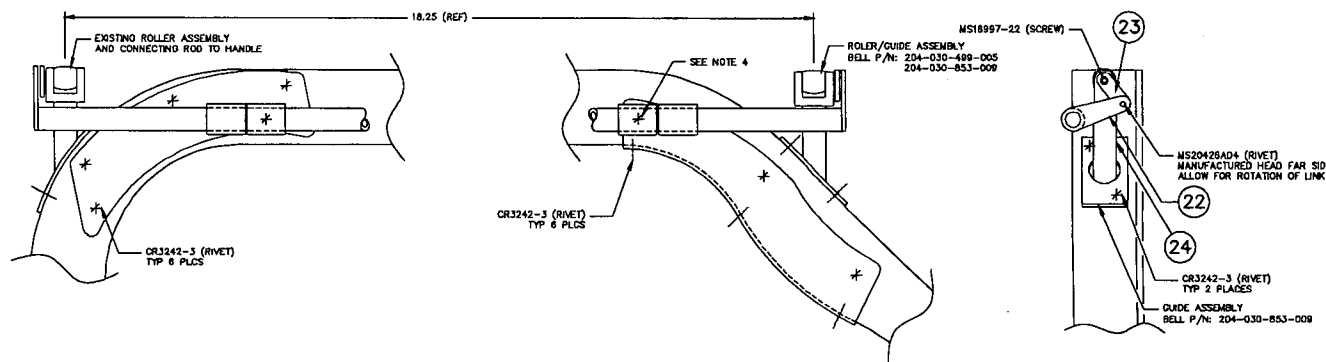
8.2 QC3 EC 07.02.23

063 SHEET. 36 SF.
3/4 4130 → 188 F.

NOTICE

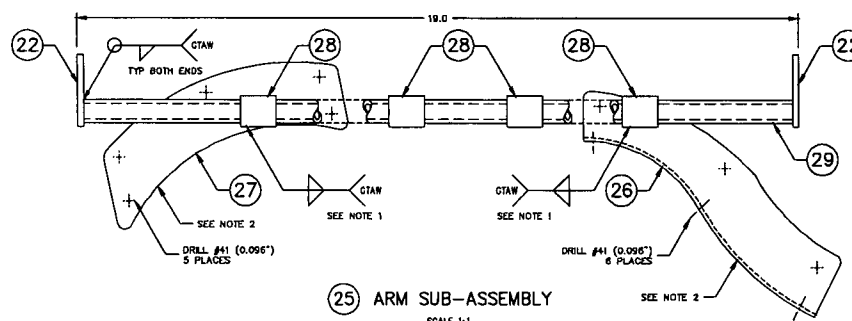
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INNER PAIR OF ARM GUIDES CHANGED FROM WELDED TO RIVETED	BW	15 AUG 2000



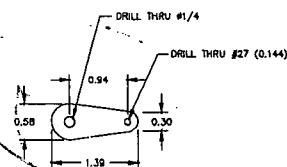
UPPER DOOR LATCH ASSEMBLY

SCALE 1:1



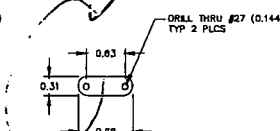
(25) ARM SUB-ASSEMBLY

SCALE 1:1



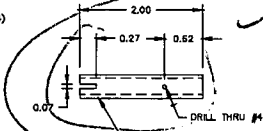
(22) LUG

SCALE 1:1



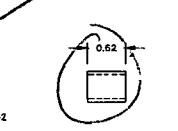
(23) LINK

SCALE 1:1



(24) ROD

SCALE 1:1



(28) ARM GUIDE

SCALE 1:1

NOTES FOR SHEET 3.

1. WELDING OF 4130 STEEL ALLOY TO BE COMPLETED BY GTAW METHOD TO AWS D6.05. WELDING ROD SHALL CONFORM TO AWS 6057A OR LATER REVISION.
2. HEAT AND FORM DOOR PLATES (ITEM 26 & ITEM 27) TO SHAPE OF DOOR JAM. PILOT HOLE LOCATIONS ARE APPROXIMATE. MAINTAIN 20 EDGE DISTANCE.
3. THOROUGHLY DEGREASE, PRIME, AND PAINT ALL SURFACES AFTER ASSEMBLY.
4. OUTER PAIR OF ARM GUIDES (ITEM 28) WELDED TO DOOR PLATES AS SHOWN. INNER PAIR OF ARM GUIDES LEFT LOOSE UNTIL ASSEMBLY WITH DOOR AND THEN FASTENED TO ARM WITH CR3242-3 RIVETS AFTER ARM ALIGNMENT.

1	29	ARM	EA20469-29	4130 STEEL	MIL-T-6736	#3/8 O.D. x 0.093 WALL
1	28	ARM GUIDE	EA20469-28	4130 STEEL	MIL-T-6736	#1/2 O.D. x 0.063 WALL
1	27	DOOR PLATE	EA20469-27	MILD STEEL		0.063" SHEET
1	26	DOOR PLATE	EA20469-26	MILD STEEL		0.063" SHEET
1	25	ARM SUB-ASSEMBLY	EA20469-25			
1	24	ROD	EA20469-24	4130 STEEL	MIL-T-6736	#3/8 O.D. x 0.093 WALL
2	23	LINK	EA20469-23	4130 STEEL	MIL-S-18729	0.063" SHEET
2	22	LUG	EA20469-22	4130 STEEL	MIL-S-18729	0.063" SHEET
1	21	DOOR COVER PANEL	EA21469-21			
1	20	FLIGHT MANUAL SUPPLEMENT 2148, 2148-1	EA21469-20			
1	20	FLIGHT MANUAL SUPPLEMENT 212, 412	EA21269-20			
1	20	FLIGHT MANUAL SUPPLEMENT 205A, 205A-1	EA20569-20			
1	20	FLIGHT MANUAL SUPPLEMENT 2048	EA20469-20			
1	19	EAGLE SERVICE INSTRUCTION	EA20469-19			
1	18	DOOR INNER SKIN	EA20469-18			
1	17	ANGLE	EA20469-17			
1	16	ARM REST ASSEMBLY	EA20469-16			
1	15	INSTRUMENT PANEL	EA20469-15			
1	14	WINDOW RETAINER	EA20469-14			
1	13	INSTRUMENT WINDOW	EA20469-13			
1	12	FORWARD RIB	EA20469-12			
1	11	ANGLE	EA20469-11			
1	10	REARWARD RIB	EA20469-10			
1	9	ANGLE	EA20469-09			
1	8	PLACARD - INSTRUMENT PANEL	EA20469-08			
1	7	ANGLE	EA20469-07			
1	6	ALUMINUM STRIP	EA20469-06			
1	5	RUBBER STRIP	EA20469-05			
1	4	DOOR LATCH ASSEMBLY	EA20469-04			
1	3	PLEXIGLASS BUBBLE WINDOW	EA20469-03			
1	2	INSTALLATION - DOOR MOUNTED INSTRUMENTS				
1	1	INSTALLATION - BUBBLE WINDOW				

QTY. DASH NO. DESCRIPTION PART NO. MATERIAL MATERIAL SPEC. STOCK SIZE

BASIC CODE		DASH NO. FOR DIA H=HEAD NEAR SIDE F=HEAD FAR SIDE		APPROVALS E. BURGDON DATE 26 AUG 1991	
D=HOLE OQT = # OF SHEETS TO BE DRILLED C=COUNTERSINK		DASH NO. FOR LENGTH		CHECKED: STRESS:	
BASIC CODES: BJ = MS20470AD BQ = MS20470AD LZ = MS20470AD CX = MS20470AD		* INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ±0.010 X.XXX ±0.003 X.X ±0.1	
SCALE AS NOTED SHEET 3 OF 3		DWG. SIZE A1		DWG. NO. D2046901	
				REV. 1	

AERO DESIGN LTD.
CONVEYING ENGINEERS, TRANSPORT CHARTER APPROVALS, AIR CRO
1004 HAVEN ROAD S.E. CALGARY, AB T2C 2Y2
EAGLE COPTERS LTD.
803 HAVEN ROAD N.E. CALGARY, ALBERTA, T2C 2Y2
BELL 204, 205, 212 & 214
VERTICAL REFERENCE DOOR
INSTALLATION